Work Orde Wednesday, Octo				*125	576.3*							Page 1
Item ID: Revision ID:	D3575-1		A	Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Cargo Floor P	Protector								Stop	*N	S2*
Start Date:	11/12/14	Start Qty: 1.00	*1*		Cust Item 1	D:						
Required Date:	11/17/14	Req'd Qty: 1.00	*1*		Customer:							
Reference:			•							_		
Approvals:	Process Pla	in: MUS	Date: 14-10-22	Tooling:	Da	ate:			Run	Start	^IVI	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3575	Rev	' A										
*100 *100*		FLOW WATER JET		0.00				(i)			De 14,	14/12
Waterjet FLOW CNC Waterje	et			0.00							/	
¹¹⁰ *11∩*		QC2- Inspect parts off m	achine FAI/FAIB	0.00				(i)		DA 50	S 1 hz 14	lu la

0.00

Memo

Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / L	JPDATE			_	AEROSPACE
QA Closed:			Date:							\	Wor	k Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST I	DEPA	\RTMENT,	/PROCESS	
					_	Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	\exists	Pro	d. Eng. Coor.	Quality
			-			Use-as-is			noforming	Finishing			re/Packaging	Other
NCR N	No					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Descr	ription of work order update	Ī	nitial	Ac	ction		Sign &	***	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Design	\Box													
Doc/Data			·											
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training	_										İ			
Transport									·					·
Unapproved				l			<u> </u>							
							FAL	JLI CA	regory					
Landir [General Bend		ا دمانم اد) wa awa wa	r		outside Dime	: Г	
	_	nding	t Concer	.+-:-	-	BOM/Route		Grain	rogram	}			 - -	Pressure/Forced Set-up
	—	acks	it Concer	itric	-	Broken/Damage/Defect		Hardwa		}		ver/Under	-	-
	—		k/Ripple	Mayo	-	Burrs	\vdash	ł		Ingualified		art Incorrec	}-	Temperature/Cure Weld
	—	imp/kiii iffs	k/Kippie	/ wave		Contamination	\vdash	1	ion Incomplete/U	·		art Lost/Mi art Moved	SSITIE	
		ushing				Countersink	\vdash	1	ions Incomplete/ gned/off center	⊢		ositioned W	L Vrong	Wrong Stock Pulled
	_	usning eat Treat	t			Cut Too Short	-	Mislabe		1	_	ositioned w	_	Other
	_		Strip in	Tube		Drawing	${f oldsymbol{ o}}$	Misrea		L		OWEI LUSS/.		Totalei
		arks/Ch		IUDE		Drill Holes		Off-set			_			
	-		equence			Finish	\vdash	1	Calibration		_			
			ist in Tub			Fit/Function	H	i	Sequence		_	<u> </u>		

Work Ord Wednesday, Oc		5763 4 12:34:28 PM			*125	5763*							Page 2
Item ID: Revision ID: Item Name:	D3575-1 Cargo Floor F	Protector			Accept	*N900	040	100)*	Setup	Start Stop	*N!	S1* S2*
Start Date: Required Date Reference:	11/12/14	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item :						IVI	
Approvals:		an:			Tooling: _ SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 120 *1 20* QC Quality Control	ID	Operation Description QC8- Inspect parts - seco	and check		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS 38 9-89 NNY 7 N 2014
130 *120* Small Fab Small Fab		Small Fab Memo Deburryf ne	cessary.	W/A	0.00 DAS 38 9-89								
*140 *140* QC Quality Control		QC5- Inspect part compl	eteness to st	tep on W/O	0.00 0.00 DAS 38 9-89								·

DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / L		Vork Order u <u>:</u>	adata only	AEROSPACE
QA Closed.			Date.							· · · · · · · · · · · · · · · · · · ·	vork Order up	date only	
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	•
	•		•			Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o.					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desci	ription of work order update	1	nitial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling		i											
Handling/Pre													
Material													
Operator													
Offset/Setup									İ				
Process													
Supplier									,				
Training	L_						į					1	
Transport	<u> </u>												
Unapproved													
							FAI	ULT CA	TEGORY				
Landi		1				General	_	,		_		-	
		Bending			<u> </u>	Bend		1	Program	_	Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		_	Over/Under	tolerance	Set-up
		Cracks			L	Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/	Unqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete	e/Unclear	Part Moved	Ĺ	Wrong Stock Pulled
	$ldsymbol{ld}}}}}}}$	Crushing				Countersink	<u></u>	Misalig	gned/off center	r	Positioned V	Vrong	
	<u></u>	Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d				
	L_	Marks/Ch	atter			Drill Holes		Off-set					
			Finish	Out of Calibration									
Wave/Twist in Tube					Fit/Function		Out of	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde Wednesday, Octo		25763 4 12:34:28 PM		*125	5763*							Page :
Item ID: Revision ID:	D3575-1			Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Cargo Floor	Protector								Stop	*N:	S2*
Start Date:	11/12/14	Start Qty: 1.00	*1*		Cust Item 1	D:						
Required Date:	11/17/14	Req'd Qty: 1.00	*1*		Customer:							
Reference:			•									
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:			Run	Start	^IVI	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description	Obc	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
150		Identify as per dwg & Sto	ck Location	0.00								
150 Packaging			660126436	0.00						acing i	DA E8	
i ackaging		Memo	_	0.00				NUI	1277	J14	9.0 0.0	

160

Packaging

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

Memo

0.00

14/12/2 A) mf 14-11-27

DQA:			Date:		WORK ORDER NON-CONFORMANCE / UPDATE								***	T A A C
QA Closed:			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / U				_	AEROSPACE
QA Closed.			Date:							VV	ork Order up	idate only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	-					Rework			Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part f	No.					Scrap		1	Machining	Small Fab	Proc	d. Eng. Coor.		Quality
	-					Use-as-is			noforming	Finishing	4	e/Packaging		Other
NCR I	۱o					Suspected Unapproved			Large Fab	Composite		Supplier		
D 4	Т	_			D			*,* 1	Γ .		T 61 . 0 . 1			
Root	ŀ	Data	C+		Desci	ription of work order update		Initial		tion	Sign &	V = -:'6' = - A' = -		001
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Desc	ription	Date	Verification	\dashv	QC Inspector
Design														
Doc/Data	\dashv												- 1	
Equip/Tooling Handling/Pre					ļ									
Material	\dashv									•				
Operator	-													
Offset/Setup			•		<u> </u>					•				
Process	\dashv													
Supplier	\neg													
Training	Н													
Transport					<u> </u>									
Unapproved									·					
							FAI	ULT CA1	ΓEGORY					
Landi	ng G	ear				General					_			
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	:t [Temperature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/U	nqualified	Part Lost/Mi	ssing		Weld
	-	Cuffs				Contamination		4	ions Incomplete/	Unclear	Part Moved			Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink	\vdash	1 ~	ned/off center		Positioned W	_		
		Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/S	Surge		Other
	$\overline{}$	Inspection	•	Tube	<u> </u>	Drawing	$\overline{}$	Misread	t					
	_	Marks/Ch			<u> </u>	Drill Holes		Off-set						
Turning Sequence Finish				Out of Calibration										
Wave/Twist in Tube				Fit/Function	Out of Sequence									

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Picklist Print

Wednesday, October 22, 2014 12:34:28 PM

Work Order ID: 125763

125763

Parent Item:

D3575-1

D3575-1

Parent Item Name: Cargo Floor Protector

Start Date: 11/12/14

Required Date: 11/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
MLEXS.125-F60029-04		Purchased	No		100	sf	5,518.686	8	10		, /
#N41 EVO 4	05 500	000 04	بالدا					طماد			//

MLFXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location	Loc Oty	Loc Code	
MAT019	2958.68678		
124866	106		
m126425	160.925		
m127934	665		
m128746	336.17		
(m129759)	1690.59178	4	16.666
SABIC	2560		
m130209	2560		

Page 1

DQA:		Date:												
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT	ΓΕ			A E R O S P A C	U E	
QA Closed:		Date:							W	ork Order up	date only			
Work Order	••				DISPOSITION			AG	GAINST DE	PARTMENT	PROCESS			
vvoin order	·				Rework			Skid-tube Cro	sstube		Water Jet	Engineering	1	
Part No	D .				Scrap			⊢	nall Fab	Pro	d. Eng. Coor.	Quality	1	
			-		Use-as-is			~ <u>—</u>	nishing		e/Packaging	Other	1	
NCR No	o				Suspected Unapproved			Large Fab Com	nposite		Supplier]	
Root				Desci	ription of work order update	ı	nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design														
Doc/Data		Į												
Equip/Tooling														
Handling/Pre														
Material														
Operator								:						
Offset/Setup	_													
Process														
Supplier]				
Training	_	İ								1				
Transport														
Unapproved														
						FAI	ULT CA	TEGORY		·				
Landing				_	General		1			1		¬		
-	Bending			—	Bend		1	Program	-	Outside Dim	<u>-</u>	Pressure/Forced		
-	Centre No	ot Concei	ntric		BOM/Route		Grain		<u> </u>	Over/Under	}-	Set-up		
-	Cracks	1 (5)		-	Broken/Damage/Defect		Hardwa			Part Incorred	· -	Temperature/Cure	:	
-	Crimp/Kir	ік/Кірріе	:/Wave	-	Burrs	-	1	ion Incomplete/Unqualific		Part Lost/Mi	ssing	Weld		
-	Cuffs			-	Contamination	-	ł	tions Incomplete/Unclear		Part Moved	<u>,</u> L	Wrong Stock Pulle	đ	
<u> </u>	Crushing			-	Countersink	_	1 .	gned/off center		Positioned W				
-	Heat Trea		T b	ļ	Cut Too Short	\vdash	Mislabe			Power Loss/S	surge	Other		
-	Inspection		equi	-	Drawing	-	Misrea							
· -	Marks/Ch				Drill Holes	_	Off-set							
-	Turning So			<u> </u>	Finish	<u> </u>	1	Calibration						
	Wave/Tw	ist in Tub	Эе		Fit/Function		JOut of !	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order: 175	763
Description: Cabin Floor Protector	Part Number: D3	575-1
Inspection Dwg: D3575 Rev: A	Pag	e 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.64			U-0202	
1.00	+/-0.030	1.00			tape	·
3.50	+/-0.030	3.50	/			
16.00	+/-0.030	16.0-	/			
23.13	+/-0.030	23.13	_			***
26.88	+/-0.030	26.88	/			
27.69	+/-0.030	27.69	_			
4.25	+/-0.030	4.25	7	· · · · · · · · · · · · · · · · · · ·		
9.63	+/-0.030	9.63				
16.13	+/-0.030	16-13	/			
28.06	+/-0.030	28.01				
32.15	+/-0.030	32-15	/			
2.00	+/-0.030	2.22				
3.50	+/-0.030	3.50	/			
14.25	+/-0.030	14.25	1	·· -		
25.13	+/-0.030	25.13	/			
29.38	+/-0.030	29,35	_			
30.13	+/-0.030	36.10	/			
1.25	+/-0.030	1.25	_			
3.38	+/-0.030	3.36	/			·
5.00	+/-0.030	5. cu	/			·
6.50	+/-0.030	6.50	_	****		
26.13	+/-0.030	26.13				
31.50	+/-0.030	31.50				

Measured by: 50

Audited by: 38

Prototype Approval: N/A

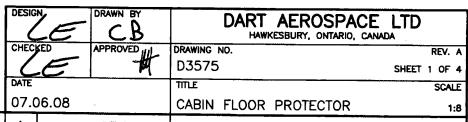
Date: N/OV 7 11 7014

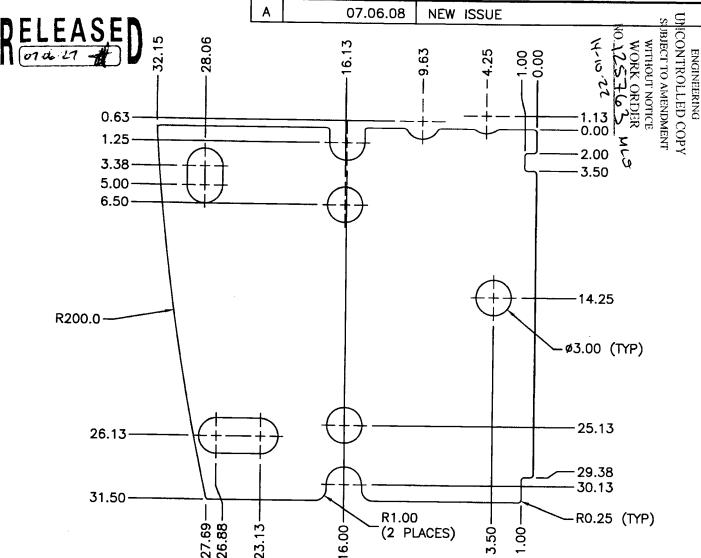
Date: N/A

Kev	Date	Change	Revised by A	Approved
Α	08.02.29	New Issue	KJ/DD	1,000
				

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D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

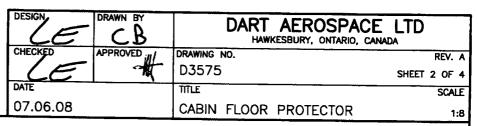
NOTES:

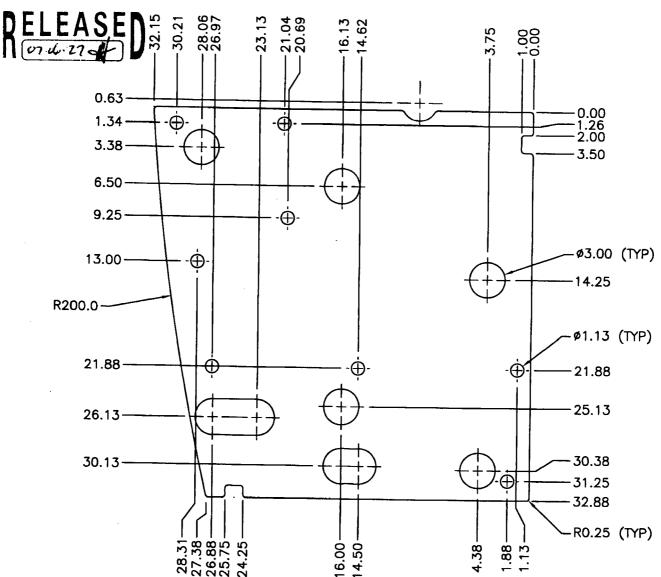
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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D3575-3 CABIN FLOOR PROTECTOR

NOTES:

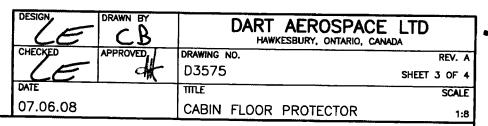
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

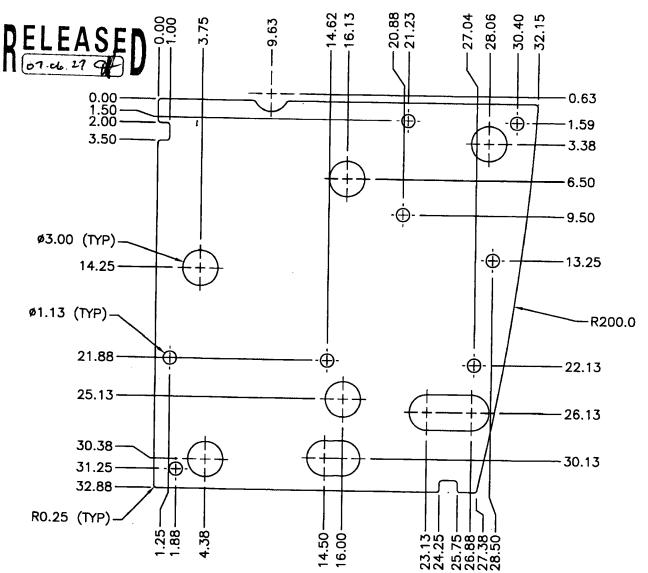
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D3575-4 CABIN FLOOR PROTECTOR

NOTES:

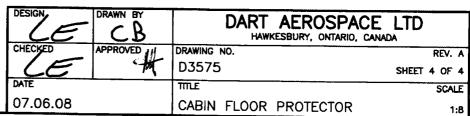
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

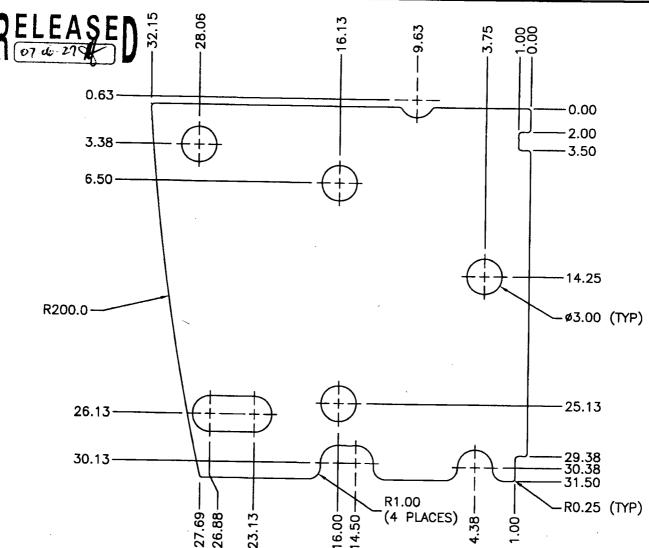
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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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